

Work Order ID 61456

Wednesday, August 25, 2010 2:31:45 PM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 8/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-8-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

*N/A*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M112507 / M114877								BE 10/08/26
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end 138.60" from front of tube								
	6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".								
	7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".								BE 10/08/30
	8-Open using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

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Wednesday, August 25, 2010 2:31:45 PM

Page 3

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Required Date: 9/9/2010 Req'd Qty: 1.00

Customer:

Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00

8/10/08/30



QC

Memo

0.00

Quality Control

⑩

116

QC10- Inspect visual per QSI004- ground welds

0.00

8/10/08/30



QC

Memo

0.00

Quality Control

⑩

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

①

BE 10/08/30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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**Work Order ID 61456**

Wednesday, August 25, 2010 2:31:45 PM



Page 4

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Start Date: 8/27/2010 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-8-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 25, 2010 2:31:45 PM

Page 5

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Cust Item ID:

Required Date: 9/9/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.  
cure time before cutting☐Start Date: 10/08/30 ☐

Time: 2:11/8

☐Finish Date: 10/6/31 ☐

Time: 2:00 PM

A/R ☐ Sikaflex-291 ☐ M1151H ☐

Sikaflex expiry date: 01/2011

10/08/30  
BE 08

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 25, 2010 2:31:45 PM

Page 6

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Start Date: 8/27/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/9/2010 Req'd Qty: 1.00




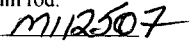

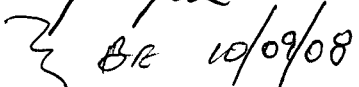
Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
160  Skidtubes Skidtubes	Skidtubes  Memo 1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. A/R Aluminum Rod  2-Grind welds flush as per Dwg D2650. 3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr	0.00 0.00							 

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 25, 2010 2:31:45 PM



Page 7

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/27/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Skidtubes Skidtubes	HandFinishing  Memo Install D2680-041 Nut Plate as per Dwg D2650	0.00 0.00	{ BE 10/09/08			_____	_____	_____	_____
180  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00	S 10/09/08			_____	_____	_____	_____
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	S 10/09/08			(X) _____	_____	_____	_____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 25, 2010 2:31:45 PM

Page 8

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Start Date: 8/27/2010 Start Qty: 1.00

Required Date: 9/9/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

⇒ 10/09/16

0.00

x1

Memo

✓ Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

205



SprayPaint

Spray Painting

Spray Painting per QSI005 4.2

0.00

Memo

Spray paint Delfleet Blue  
Primer B 114424  
Deflect Blue 113171  
Clear Delfleet B 115506

0.00

M 10 09 23 ①

206



QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

25 10-09-24 (x1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 25, 2010 2:31:45 PM



Page 9

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230 	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	<p>1-Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.</p> <p><input checked="" type="checkbox"/> A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>M114093</u></p> <p>Sikaflex expiry date: <input type="checkbox"/> <u>10/10</u></p> <p>2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive</p> <p><input checked="" type="checkbox"/> 3-Install MS27039-4-06 Screw as per DEO 9153</p> <p><input checked="" type="checkbox"/> 4-Inspect for foreign object per QSI 024</p> <p><input checked="" type="checkbox"/> 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive</p> <p>A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>M114093</u></p> <p>Sikaflex expiry date: <input type="checkbox"/> <u>10/10</u></p> <p><input checked="" type="checkbox"/> 6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4</p> <p>Batch: <u>M115028</u></p>								

7 M 10/09/27

1 0

W/O:		WORK ORDER CHANGES					
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Wednesday, August 25, 2010 2:31:45 PM



Page 10

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		810109124					
250  Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP D206-642-441 Location: _____ PPP Rev:	0.00 0.00		610029		10/9/28sf			
260  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							10/09/28sf mf 10-9-28

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# Picklist Print

Wednesday, August 25, 2010 2:31:44 PM

Page 1

Work Order ID: 61456

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
IPP Rev: I 08-05-01 add QC3 DD verified by: EC  
IPP Rev: J 08-09-29 revF as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2620		Manufactured	No			110	Each	4.0000	1	1			
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Skidtube, 206 Skidtube

Location	Loc Qty	Loc Code
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LG	4	
----	---	--

57542	4	
-------	---	--

D2646		Manufactured	No			110	Each	72.0000	1	1			
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Aft Cap

Location	Loc Qty	Loc Code
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FP-4	63	
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57332	63	B61752
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FP6	9	
-----	---	--

52663	9	
-------	---	--

D2647		Manufactured	No			140	Each	72.0000	1	1			
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Cap

Location	Loc Qty	Loc Code
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FP	72	
----	----	--

55352	72	
-------	----	--

D2654-7		Manufactured	No			160	Each	3.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--



Web

Location	Loc Qty	Loc Code
----------	---------	----------

LG	3	
----	---	--

61264	3	
-------	---	--

B 61455

(21)

BE 10/08/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 25, 2010 2:31:44 PM

Page 2

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Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased No

170

Each

472.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

ST311

472

112314

4

113539

44

113973

424

D2649

Manufactured No

170

Each

29.0000

23

23



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

29

58545

2

60652

27

D2680-041

Manufactured No

170

Each

35.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

ST021

35

55366

35

Wednesday, August 25, 2010 2:31:45 PM

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Page 2

BE 10/02/08

B61496 (23) BE 10/09/08

1 BE 10/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, August 25, 2010 2:31:45 PM

Page 3

Work Order ID: 61456

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

230

Each

3,222.000

60

60



Insert



HL 10/09/27

Location

Loc Qty

Loc Code

PKG11

3030

114723

3030

V60

ST282

153

110511

10

114407

143

ST381

39

114654

39

AN960JD10L

NAS1149D0332J

Purchased

No

230

Each

2,501.000

62

62



Washer



HL 10/09/27

Location

Loc Qty

Loc Code

ST348

2501

110985

2501

M10985

x2

\*PTO =>

AN960JD416

NAS1149D0463J

Purchased

No

230

Each

0.0000

1

1



Washer



M115622

x1 HL 10/09/27

CR3212-4-03

Purchased

No

230

Each

1,912.000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

1912

111359

5

112314

2

114436

448

114450

83

114859

1374

2

BE 10/09/08

Wednesday, August 25, 2010 2:31:45 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Dart Aerospace Ltd

WORK ORDER CHANGES

N/O: 61456		PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP								
10/09/27	230	USE NAS1149 C0332R Qty (60) FOR WEAR SHOES BA M115698 Qty Rem chg (need to update IIW)			M	10/09/27	X60	10/09/27 S	10/09/27
10/19/27	230	USE MS 270391-1-040 Qty (60) FOR WEAR SHOES N/A						10/19/27 S	

Part No: D206-642-441 PAR #: Fault Category: NCR: Yes No DQA: Date:

Resolution: Disposition: QA: N/C Closed: Date:

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

# Picklist Print

Wednesday, August 25, 2010 2:31:45 PM

Page 4

Work Order ID: 61456

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No 230 Each 734.0000 22 22  
Plug  
10/09/27

Location	Loc Qty	Loc Code
FP	152	
51530	152	
fpa	582	
53349	411	x22
57869	171	

D2651-3 Manufactured No 230 Each 342.0000 22 22  
O-Ring  
10/09/27

Location	Loc Qty	Loc Code
FP	342	
46114	342	x22

D3535-15 Manufactured No 230 Each 20.0000 1 1  
Wearshoe  
10/09/27

Location	Loc Qty	Loc Code
FP18	20	
59236	7	
61241	13	x1

D3535-23 Manufactured No 230 Each 7.0000 1 1  
Wearshoe  
10/09/27

Location	Loc Qty	Loc Code
FP21	7	
60864	7	x1

B61830

Wednesday, August 25, 2010 2:31:45 PM

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Page 4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 25, 2010 2:31:45 PM

Page 5

Work Order ID: 61456

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-37

Manufactured No

230

Each

17.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FP

17

51654

4

56101

13

D3536-15

Manufactured No

230

Each

22.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

16

56055

4

60875

12

FP11

6

59238

6

D3536-23

Manufactured No

230

Each

10.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP011

10

60234

10

D3536-37

Manufactured No

230

Each

15.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP

15

56102

15

Wednesday, August 25, 2010 2:31:45 PM

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Page 5

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 25, 2010 2:31:45 PM

Page 6

Work Order ID: 61456

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

32.0000

6

6



Wearpad



10/09/27

Location

Loc Qty

Loc Code

FP  
55465  
FP017  
FP17  
57713  
60192  
60491

1  
1  
48  
31  
3  
3  
25

B60640

x6

D3537-3

Manufactured No

230

Each

10.0000

1

1



Wearpad



10/09/27

Location

Loc Qty

Loc Code

FP19  
59711

10  
10

B60866

x1

MS27039-1-08

Purchased No

230

Each

1,685.000

2

2



Screw



10/09/27

Location

Loc Qty

Loc Code

ST291  
110835  
114718  
115108

1685  
493  
192  
1000

x2

Wednesday, August 25, 2010 2:31:45 PM

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Page 6



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 25, 2010 2:31:45 PM

Page 7

Work Order ID: 61456



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 8/27/2010

Required Date: 9/9/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

230

Each

118.0000

1

1



10/09/27

Screw

Location

Loc Qty

Loc Code

ST292

118

109061

24

115460

94

X1

MS27039C1-08

Purchased

No

230

Each

802.0000

60

60



10/09/27

SCREW

Location

Loc Qty

Loc Code

FP

801

115336

801

ST293

1

19185

1

X60

Wednesday, August 25, 2010 2:31:45 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

614520

RELEASED  
08-07-23/17

# NOTES:

- MATERIAL: N/A
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



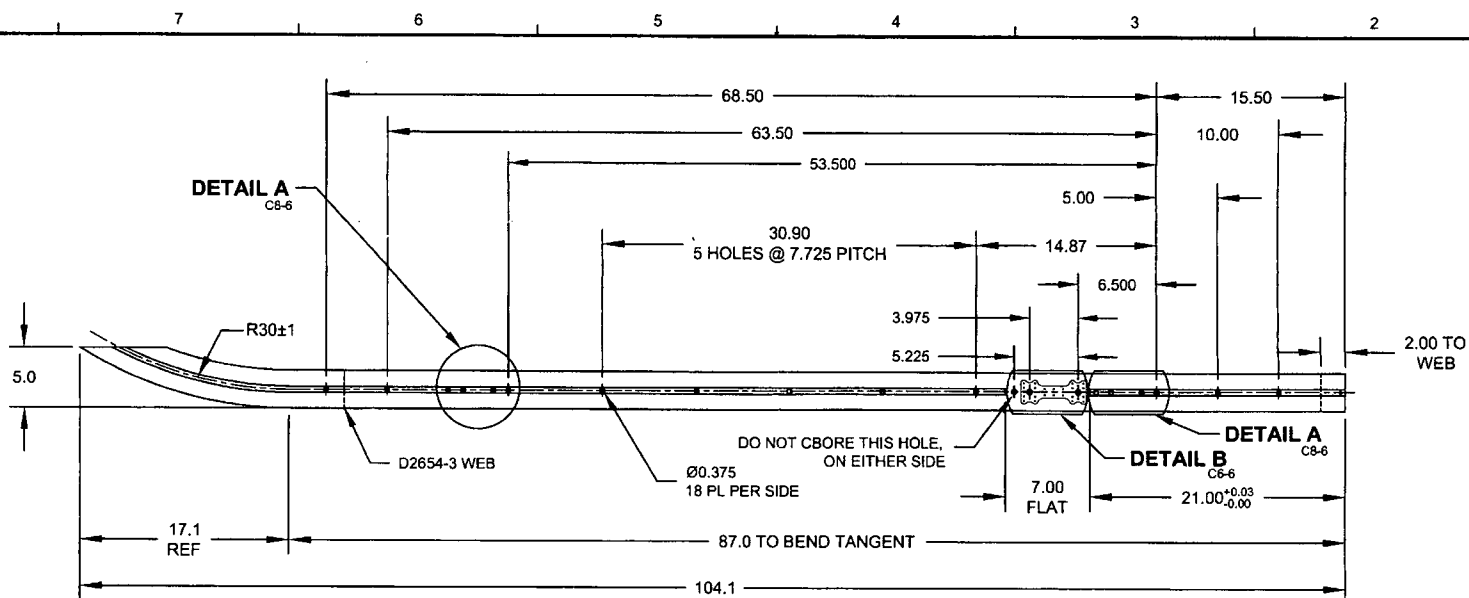
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

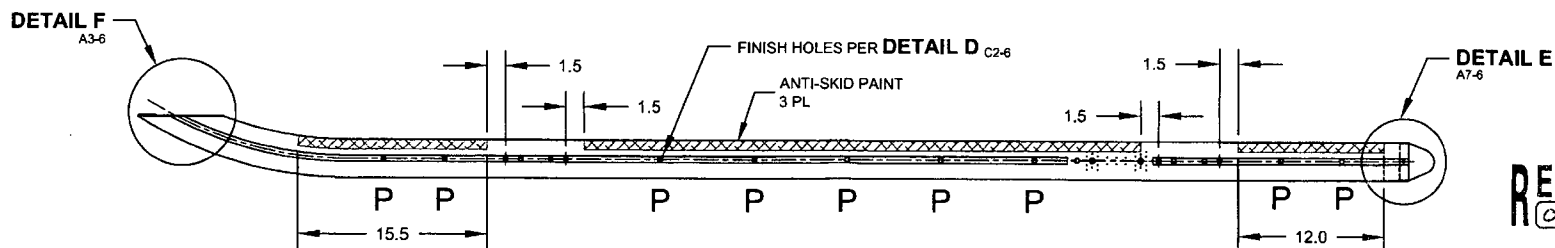
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2650-3 BENDING/DRILLING DETAIL**

761456



**D2650-3 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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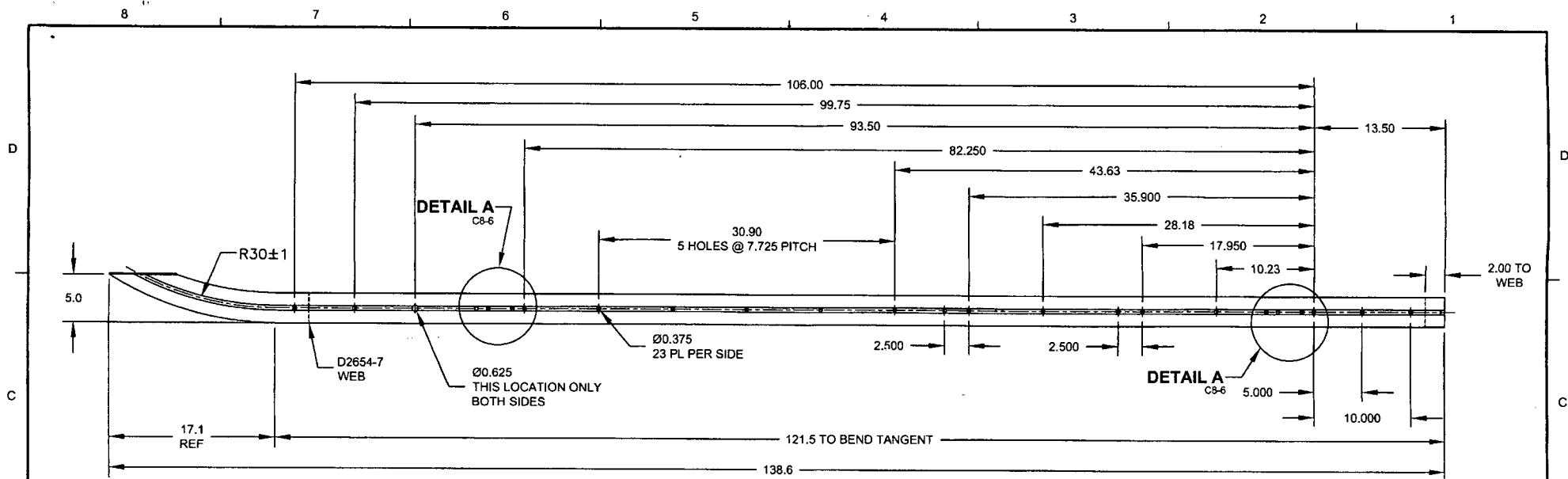
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

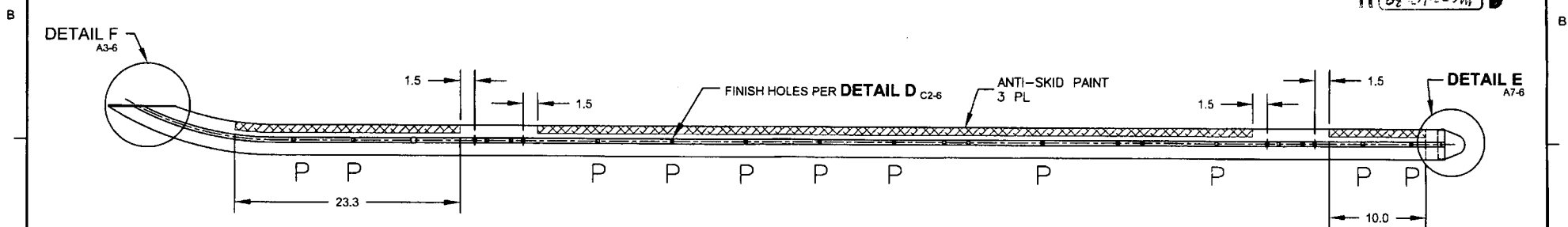
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2650-7 BENDING/DRILL DETAIL**



**D2650-7 ASSEMBLY/FINISHING DETAIL**

#61456

RELEASED  
08-07-22

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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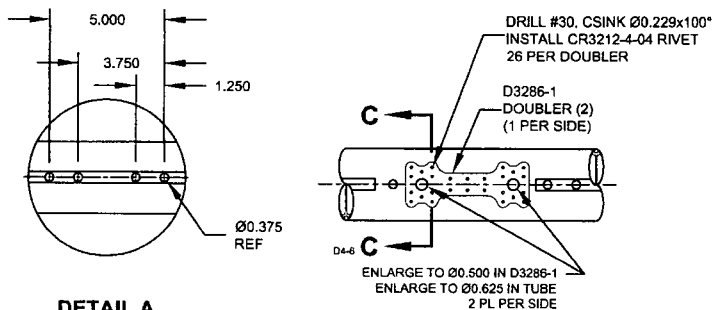
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



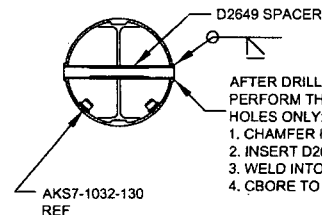
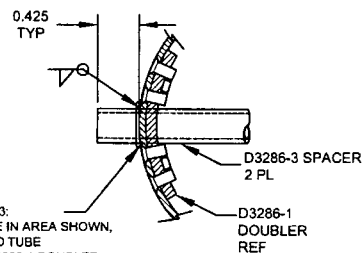
**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

**DETAIL B**  
SCALE 2X  
C3-2  
C3-3

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



**SECTION C-C** C7-6  
SCALE NONE

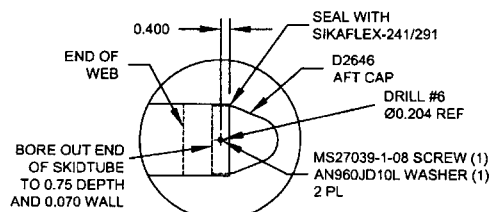


**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO Ø0.313 X 0.75 DP

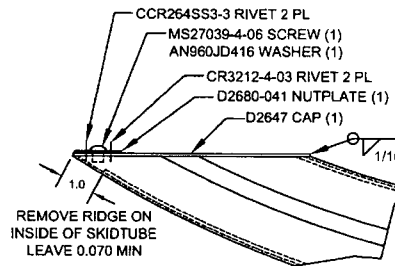
B4-2  
B4-3  
B4-4  
B4-5

*Handwritten:* # 61450



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5

ORIENTATION OF  
D2680-041






**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
68-09-22-103

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1987 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 251

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Berclay Elliott  
Job number: 61039  
Part number: D206-442-441  
Description: 206 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Del Del Date of Test Coupon 10.08.19

Welder Berclay Elliott Date of Test Coupon 10.08.19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld